Troubleshooting processing problems

Problem	Proposal for solution / diagnosis
Edging strip can easily be removed by hand. Hot melt remains on the chipboard. Grid structure of the glue applicator roll can be seen.	▶ Insufficient glue application quantity ▶ Edging strip material too cold ▶ Hot melt temperature too low ▶ Feed rate too slow ▶ Room temperature too low ▶ Insufficient contact pressure of glue applicator roll or counter roll
Edging strip can be removed by hand. Hot melt remains on edging strip to a great extent.	▶ Panel material temperature too high
Edging strip can easily be removed by hand. Hot melt remains on the chipboard. Hot melt surface is smooth.	▶ Panel too cold ▶ Edging strip too cold ▶ Wrong hot meld ▶ Incorrect bonding agent application
Glue joint is not closed.	▶ Insufficient contact pressure ▶ Edging strip too cold ▶ Missing edging strip pretension ▶ Wrong hot meld ▶ Hot meld does not set quickly enough ▶ Feed rate too high
Edging strips are only glued in the boundary areas.	▶ Insufficient contact pressure ▶ Excessive edging strip pretension ▶ Joint cut at panel part is hollow
Insufficient gluing at panel front edge of the glued edging strip or splintering edging strip.	▶ Insufficient glue application ▶ Incorrect glue applicator roll position
Milling has wavy lines.	▶ Feed rate too high ▶ Milling cutter speed to low ▶ Milling not counter direction
Edge protection tape changes colour during milling (stress whitening).	▶ Scraper blade is too thick (max. 0.1 mm) ▶ Heat milling area with hot air